

Work Order ID 56908

March 12, 2010 1:27:35 PM



Page 1

Item ID: D3694-5

Accept



Setup Start

Revision ID:

Item Name: MOUNTING PLATE ASSY

Stop



Start Date: 12/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-3-15 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3694

C

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3694

Dwg Rev: 5

Prog Rev: 2

2-Deburr if necessary

10-3-16

6061 .125

9

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

10-3-16

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

8061/12

18

Pro →

Dart Aerospace Ltd

W/O: 56908		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/17	#120	Took Qty H For inspection template	S	10/03/17	x1		S 10/03/17

Part No: D3694-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- Counter sink holes 0.204" (4 places) as per dwg D3694
2- deburr

4510/03/18 (8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

810/03/18

(x8)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10/03/19

(x5)

Ø

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time: 8:30 AM

Oven Temperature: 320°C

Finish Time: 8:00 AM

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 205

0.00



Packaging

Memo

0.00

Packaging

(XF) /

10/3/22 (S)

10/3/22 (S)

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

PH 10-3-22
(8)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 1:27:40 PM

Work Order ID: 56908



Parent Item: D3694-5

Parent Item Name: MOUNTING PLATE ASSY

Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A new issue 09-01-12 DD verified by:JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	217.0801	5.6926	6.5		



6061-T6 .125 Sheet



10-3-6

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	217.0801	
110062	1.85	
111642	19.592	
112476	32	
112567	18.7403	
113424	48.8978	
113608	96	

9

113424

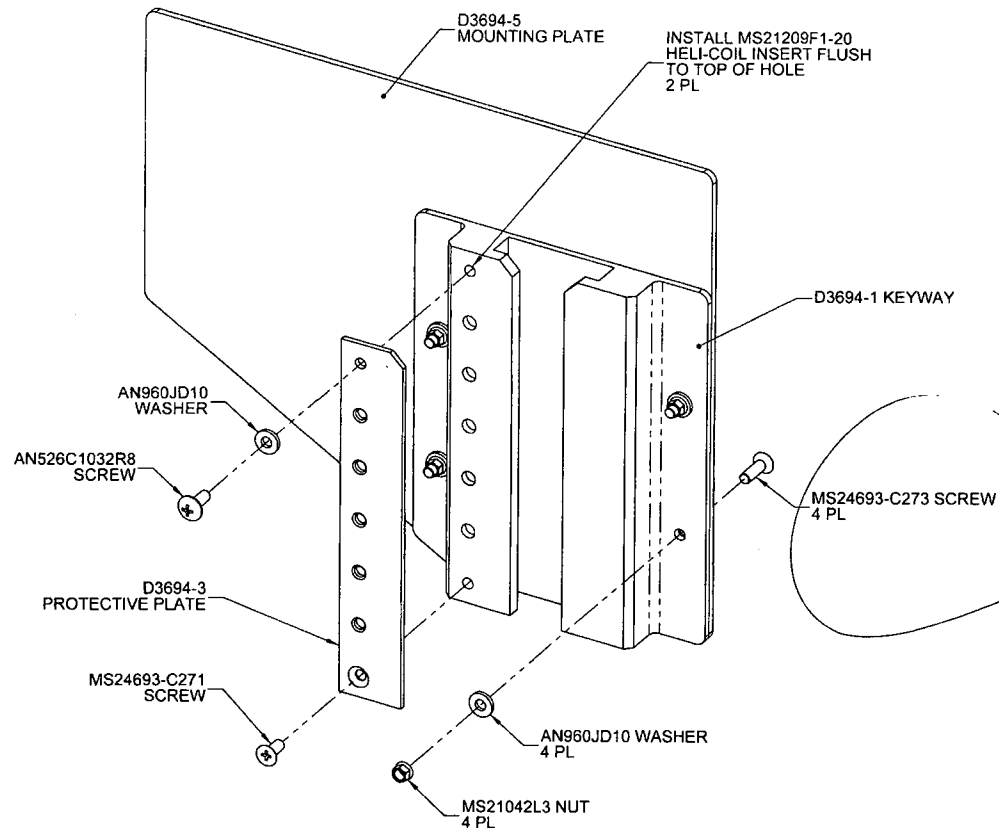
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *56908*
28-03-15

RELEASED
09/12/05/MB

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D8-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1); REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.16 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); Ø 0.10 WAS 0.075 (ZN C3-3); REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.05.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3694 TITLE MOUNTING PLATE ASSY REV. C SHEET 1 OF 4 SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

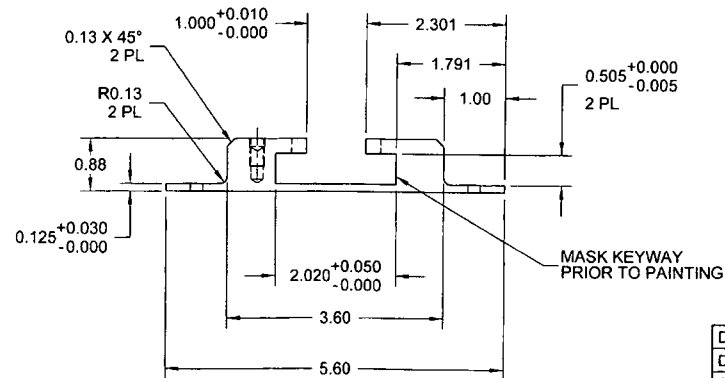
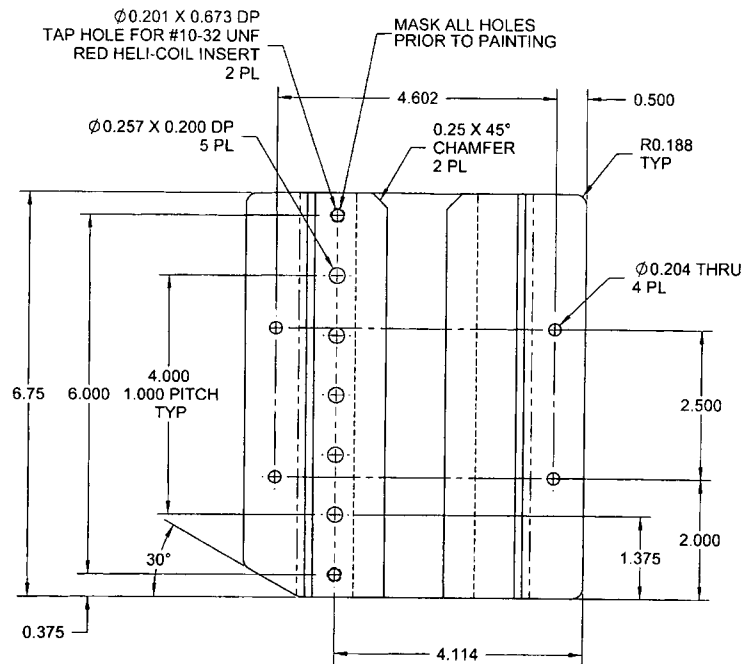
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NOTE: Date & initial all entries



D3694-1 KEYWAY

D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

W/O 56908

RELEASED
2/10/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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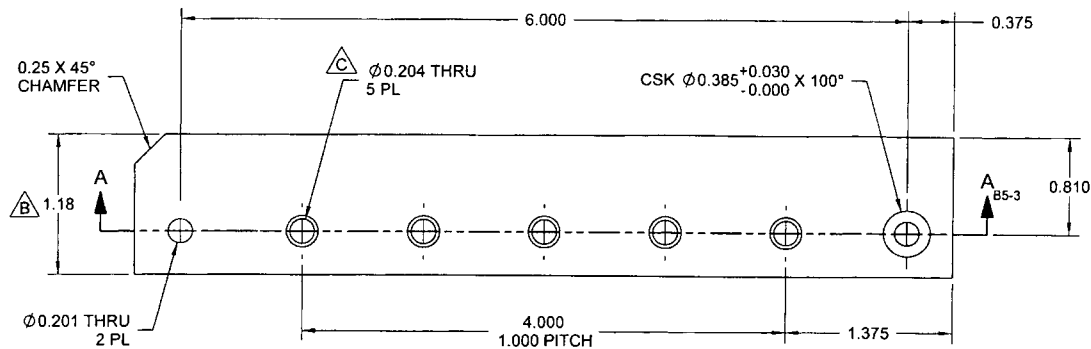
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

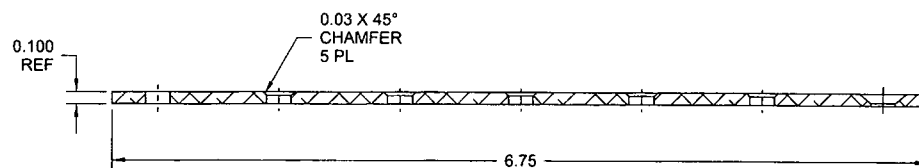
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3694-3 PROTECTIVE PLATE



SECTION A-A C3-3

w/o 56908

RELEASED
09/02/05

D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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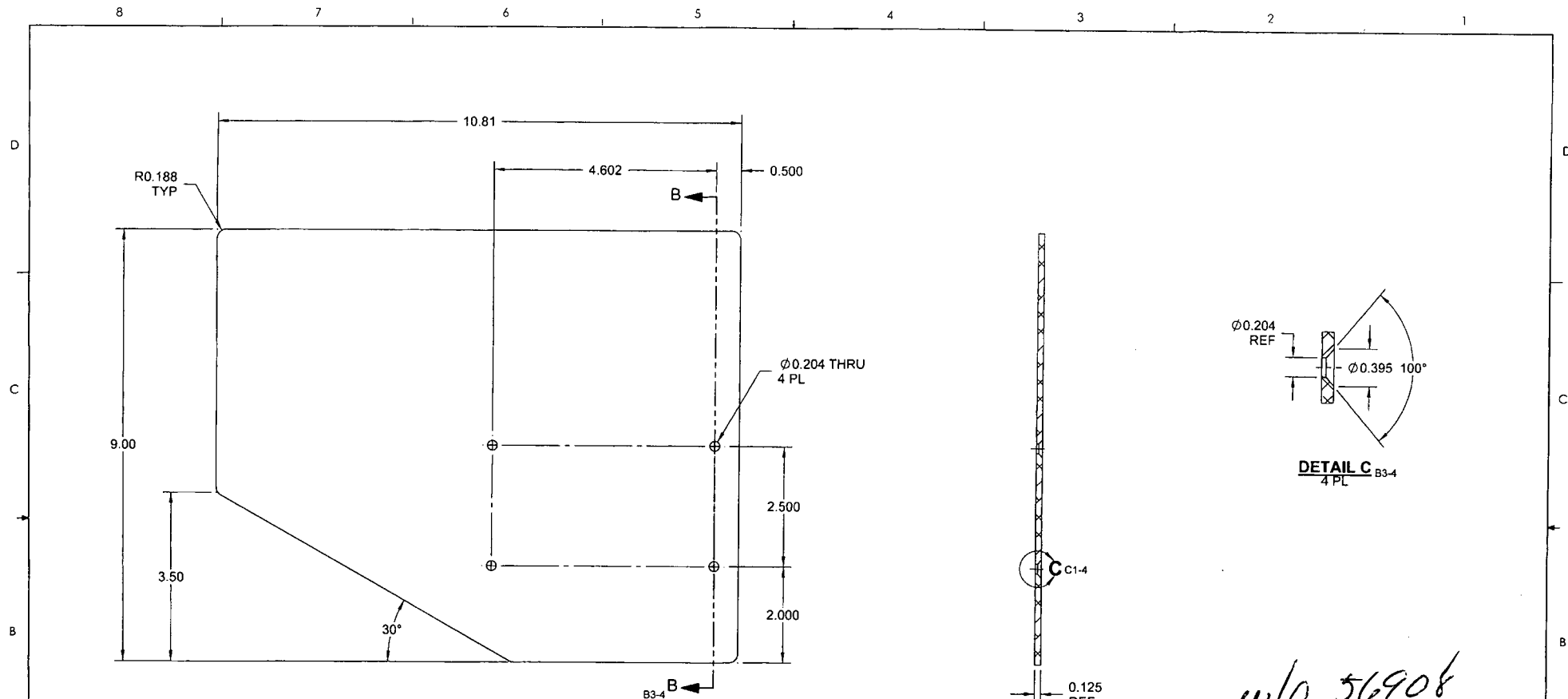
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D3694-5 MOUNTING PLATE

SECTION B-B B5-4

w/o 56908

RELEASED
6/2/05

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 4 OF 4
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DE APPR.		MOUNTING PLATE ASSY	NTS
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